

Split

Part Number : 32355 - 1  
Alternate Number : 10342  
D. Number : N/A  
Part Issue : 5/16/2007  
Part Rev : NC  
Part Issue : N/A  
Previous Rev : 31035

S.O. No. : N/A  
Type : PURCHASED PARTS

Part Number : D2646  
Drawing Number : D2646 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : N/A  
Due Date : 6/5/2007

Qty: No Unit Rate

Created By :  
Checked & Approved By : 07.05.10

Est. G 05/08/22 Hole size revised in Step 5 KJ/JLM  
Est. Rev. Changed in series 07-02-16 JLM

Material Product

Lot Number



Lot #

Machine Or Operation

Description

10

10

PURCHASING



Comments : PURCHASING

1-Check P/O 5794

07/05/10

10

1-Check as per Dwg D2646

2-Material release note required

20

20

Air Cap



Comments : QTY: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

AIR CAP

30

30

PACKAGING RESOURCE #1



Comments : PACKAGING RESOURCE #1

Package & Inspect for Transit Damage

Ensure Material Release Note is attached

40

40

DIMENSIONAL CHECK



Comments : DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

50

50

SMALL & MEDIUM FAB RESOURCE 1



Comments : SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646

2-Open holes to .250" and drill as per Dwg D2646

3-Deburr

07/06/10

07/06/10



Date: Wednesday, 5/16/2007 8:13:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1

4J

07-06-13

16

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

P/O: 4058 C207100127 (2)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



07-07-03 (2)



Comment: INSPECT SPRAY PAINT

9.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

INSERT

Batch: 12 103 418

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

4J

07-07-04 - (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



07-07-04 (2)



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



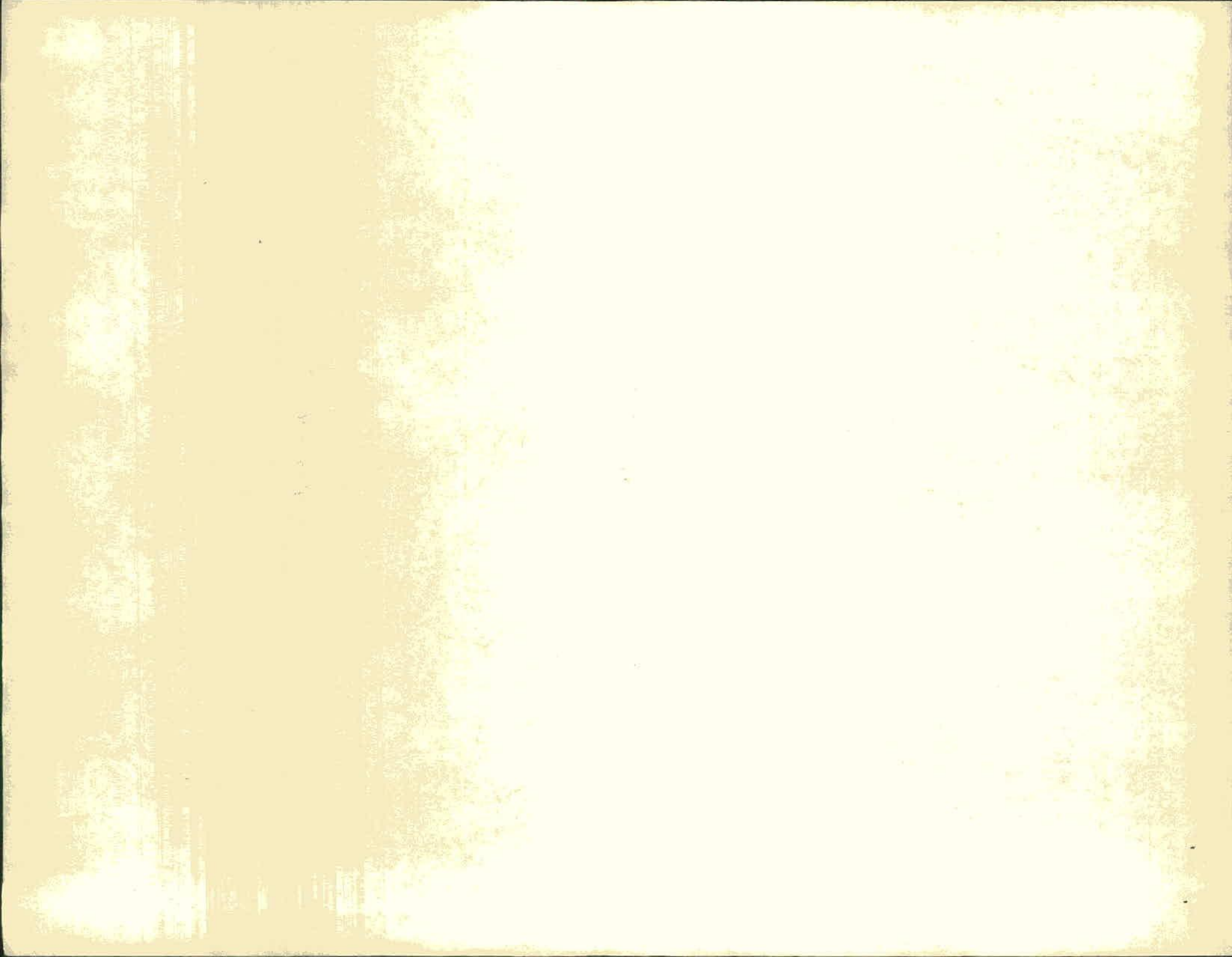
Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

4J 07-07-04 - (2)





Date: Wednesday, 5/16/2007 8:13:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



2)

Comment: FINAL INSPECTION/W/O RELEASE

12/07/04

Job Completion



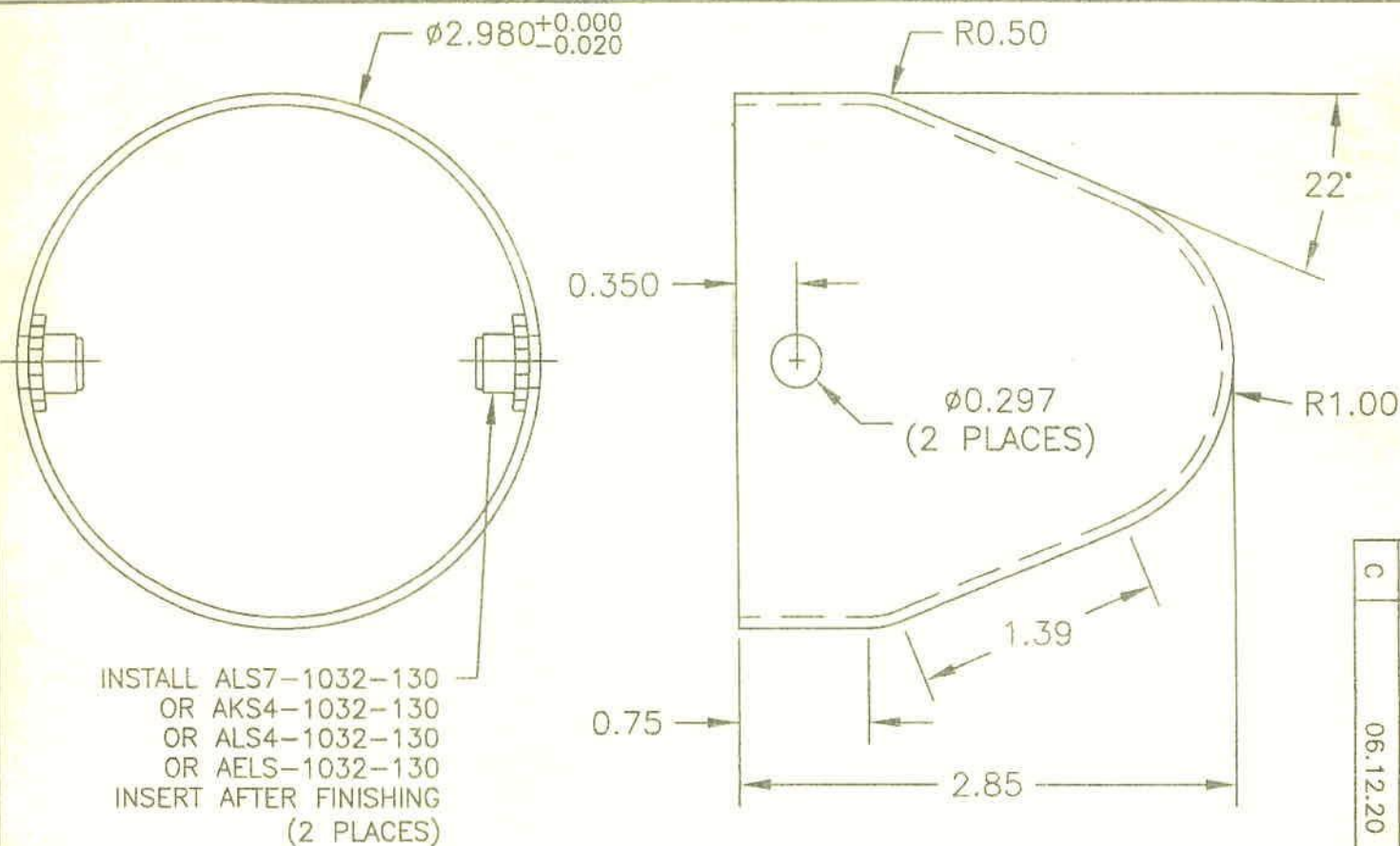
12/07/04





**DART**

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	D2646	SHEET 1 OF 1	SCALE
DATE	06.12.20	TITLE	AFT CAP	NEW ISSUE	CHANGE TO CLOSED INSERTS	1:1
A	97.03.25					
B	05.04.01					
C	06.12.20					



**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

07.02.02

UNCONTROLLED  
SUBJECT TO APPROVAL  
DATE 07.02.02  
BY 3.23.75







1480 Manheim Pike  
Lancaster Pa 17601

# CERTIFICATION OF TEST RESULTS

SOLD TO	COPPER & BRASS SALES INC 21355 WEST ELEVEN MILK ROAD SOUTHFIELD, MI 48034		SHIP TO	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212		CERT NO	0000598687
						DATE	10/26/2004
						SKID NO	322296
						SKID WGT	9.760
						PAGE	1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 218066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.014	0.001	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI  
TAIL ULTIMATE STRENGTH 12.6 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI  
HEAD ELONGATION (G.L. = 2 IN) 35.5 %  
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251 04  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557 02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
ASME SB209 1100 O, AMS 4001R 1100 O  
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL  
\*\* END OF CERTIFICATION \*\*

*Handwritten:*  
Haw  
Henry @ 5/19/04  
C/O  
Zoe @  
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

ALFRED FREEDY, LAB SUPERVISOR





# Sieg's Manufacturing Ltd.



Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: June 4/07  
Customer: Dart Aerospace  
Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
B32375	16 ✓	14G1100	N/A	✓	
B32427	50	14G1100	N/A	✓	

Notes:



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Material Certification Attached: Yes.



